Garant

GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TiAIN, Ø DC h7 (mm or inch): 12 mm or inch

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Order data

Order number	123035 12
GTIN	4045197839893
Item class	11E

Description

Version:

3-flute drill, specially developed for **use at very high feed rates**. Outstandingly suitable for **machines with high installed power** and stable operating conditions.

- Special cutter geometry with stable cutting edges and large clearance at the centre enables very high feed rates.
- The patented tip is optimised for chip flow and generates low cutting pressure with good chip breakage.

The sector-leading technology of the drill point guarantees optimum self-centring behaviour. 3 guide chamfers guarantee a stable exit from the hole and an exact roundness of the hole.

Recommendation:

Maximum drilling depth:

flute length (see table) less 1.5×nominal Ø.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

Form HB and HE supplied at the same price as HA.

Form **HB:** order with **No. 123036**.

Form **HE:** order with **No. 123035 + 129100HE**.

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 3

Tolerance nominal Ø: h7

recommended maximum drilling depth L₂: 96 mm

Overall length L: 162 mm

Shank Ø D_s: 12 mm

Feed f in steel < 1100 N/mm²: 0.5 mm/rev.

Technical description

recommended maximum drilling depth L₂96 mmNumber of cutting edges Z3StandardManufacturer's standardNominal Ø Dc12 mmFeed f in steel < 1100 N/mm²0.5 mm/rev.Shank Ø Ds,12 mmFlute length Lc114 mmTolerance nominal Øh7SeriesGARANT Master SteelCoatingTiAlNTool materialSolid carbideDrill depth up to8×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreenType of productJobber drill	Overall length L	162 mm
StandardManufacturer's standardNominal Ø Dc12 mmFeed f in steel < 1100 N/mm²	recommended maximum drilling depth L ₂	96 mm
Nominal Ø Dc12 mmFeed f in steel < 1100 N/mm²	Number of cutting edges Z	3
Feed f in steel < 1100 N/mm²0.5 mm/rev.Shank Ø Ds12 mmFlute length Lc114 mmTolerance nominal Øh7SeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to8×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Standard	Manufacturer's standard
Shank Ø D,12 mmFlute length L,114 mmTolerance nominal Øh7SeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to8×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Nominal Ø D _c	12 mm
Flute length L c114 mmTolerance nominal Øh7SeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to8×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Feed f in steel < 1100 N/mm ²	0.5 mm/rev.
Tolerance nominal Øh7SeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to8×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Shank Ø D _s	12 mm
SeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to8×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Flute length L _c	114 mm
CoatingTiAINTool materialSolid carbideDrill depth up to $8 \times D$ Point angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Tolerance nominal Ø	h7
Tool materialSolid carbideDrill depth up to8×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Series	GARANT Master Steel
Drill depth up to8×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Coating	TiAIN
Point angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Tool material	Solid carbide
ShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Drill depth up to	8×D
Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Point angle	140 degrees
Machining strategyHPCSemi-StandardyesColour ringgreen	Shank	DIN 6535 HA to h6
Semi-Standard yes Colour ring green	Through-coolant	yes, to 25 bar
Colour ring green	Machining strategy	HPC
	Semi-Standard	yes
Type of product Jobber drill	Colour ring	green
	Type of product	Jobber drill

Services

Shank grinding Type HE	129100 HE
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